

Date: Friday, 5/25/2007 8:26:07 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 206 A/B HIGH GEAR WEB
Job Number : 32622	
Estimate Number : 10455	
P.O. Number : N/A	Part Number : D26543
This Issue : 5/25/2007 S.O. No. : N/A	Drawing Number : D2654 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : E1
Previous Run : 32279	Material : N/A
Written By : _____	Due Date : 6/5/2007 Qty: 5 Um: Each
Checked & Approved By : <u>JOHNSON</u>	
Comment : Est Rev:D 99.02.04 Fixed typo, Changed procedure DM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D26005108	Extrusion 'I Beam' thin
-----	-----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 5.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2600-5	Web	B 29985

JB 7-6-6

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

1-Cut D2600-5 to length as per Dwg D2654

2-Drill pilot holes in web using drill jig DT 8018-3 as per Dwg D2654

3-Using the uni-bit, open holes to finish size as per Dwg D2654

4-Deburr holes and ends

JB 7-6-6

3.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

DP 7-6-6

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
-----	-----------------	----------------------------



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

JB 7-6-7

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ED Date: 07/06/19  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:26:07 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 A/B HIGH GEAR WEB

Job Number: 32622

Part Number: D26543

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*Final 07-06-18*



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *L6*

*Job 7-6-7*

7.0

QC21

FINAL INSPECTION/W/O RELEASE



*(5)*

Comment: FINAL INSPECTION/W/O RELEASE

*Final 07-06-19*

Job Completion



*07-26-19*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

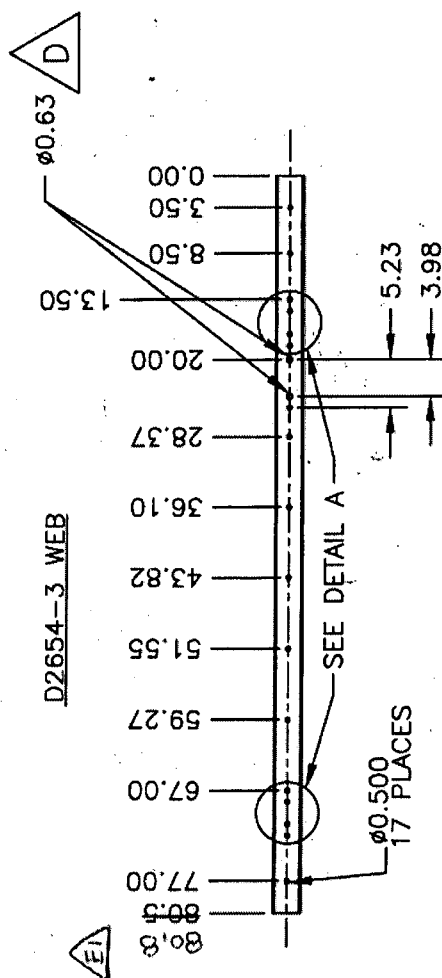
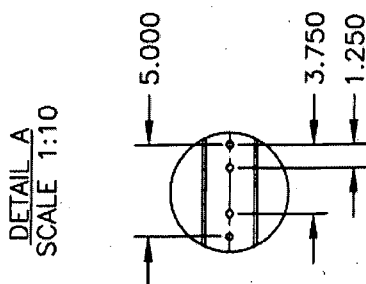
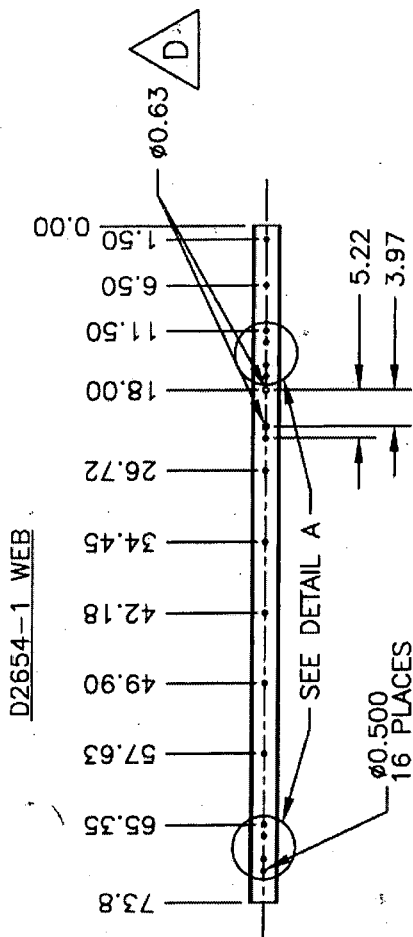
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 1 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20
A	97.03.25	NEW ISSUE	
B	97.06.26	ALTER HOLE PATRN., 0.500 WAS 0.438	
C	97.10.29	CHANGED HOLE PATTERN	
D	98.01.15	GHW HOLES CHANGED TO $\phi 0.63$	
E	04.05.26	CHANGE LENGTHS, REFORMAT	
E1 <i>CP</i>	<i>[Signature]</i> 04.08.24	PER TOOLING; 80.8 WAS 80.5	

RELEASED  
04.06.22



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32622

MAKE FROM D2600-5-108 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Copyright © 1997 by DART AEROSPACE USA, INC.

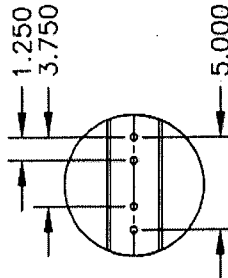
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.



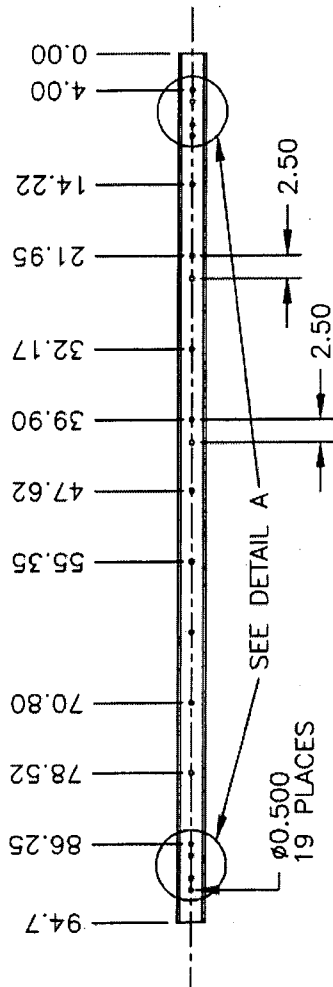
DESIGN <i>UP</i>	DRAWN BY <i>UP</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2654	REV. E SHEET 2 OF 2
DATE 04.05.26		TITLE WEB	SCALE 1:20

RELEASED  
04.06.22

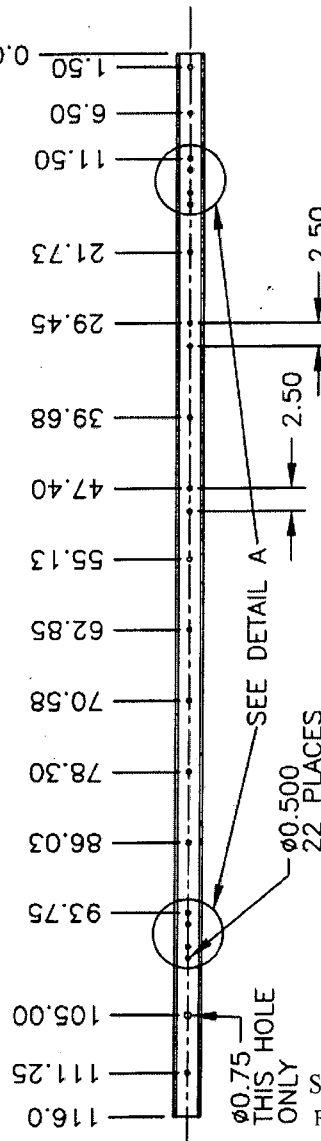
DETAIL A  
SCALE 1:10



D2654-5 WEB



D2654-7 WEB



MAKE FROM D2600-7-125 EXTRUSION  
FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 32622

Copyright © 1997 by DART AEROSPACE USA, INC.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

